

Work Order ID 91646 - 2
October-18-12 9:54:54 AM

91646

Page 1

Item ID: D3885-1

Revision ID:

Item Name: Standard Web

Start Date: 10/18/12 Start Qty: 10.00

Required Date: 11/02/12 Req'd Qty: 10.00

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: *P*

Date: *12-10-18*

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3885

B

100

0.00

100

Purchasing

Purchasing

Memo

0.00

Purchasing

Issue P/O: *18242*

Supplier: George A. Wright & Son Ltd. *Wright*

Machine as per Dwg D3885

Conformity sheet required

CL 12/10/24 (17)

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Packaging

Memo

0.00

(16)

SP 12-12-12

D 3885-1

Work Order ID 91646

October-18-12 9:54:54 AM

91646

Page 3

Item ID: D3885-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Standard Web
 Start Date: 10/18/12 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 11/02/12 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>LG</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

4 CF 12-12-20

13/1/10

MF
12-12-21

Picklist Print

October-18-12 9:54:53 AM

Page 1

Work Order ID: 91646
 Parent Item: D3885-1
 Parent Item Name: Standard Web

Start Date: 10/18/12 Required Date: 11/02/12
 Start Qty: 10.00 Required Qty: 10.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3882-1-130 Extrusion "I" Beam		Manufactured	No			110	Each	39.0000					

12/10/27 14

Location	Loc Qty	Loc Code
HALL	30	
51826	30	
LG	9	
51826	9	

14

D3885-17

x14

SP 12-12-12

91646

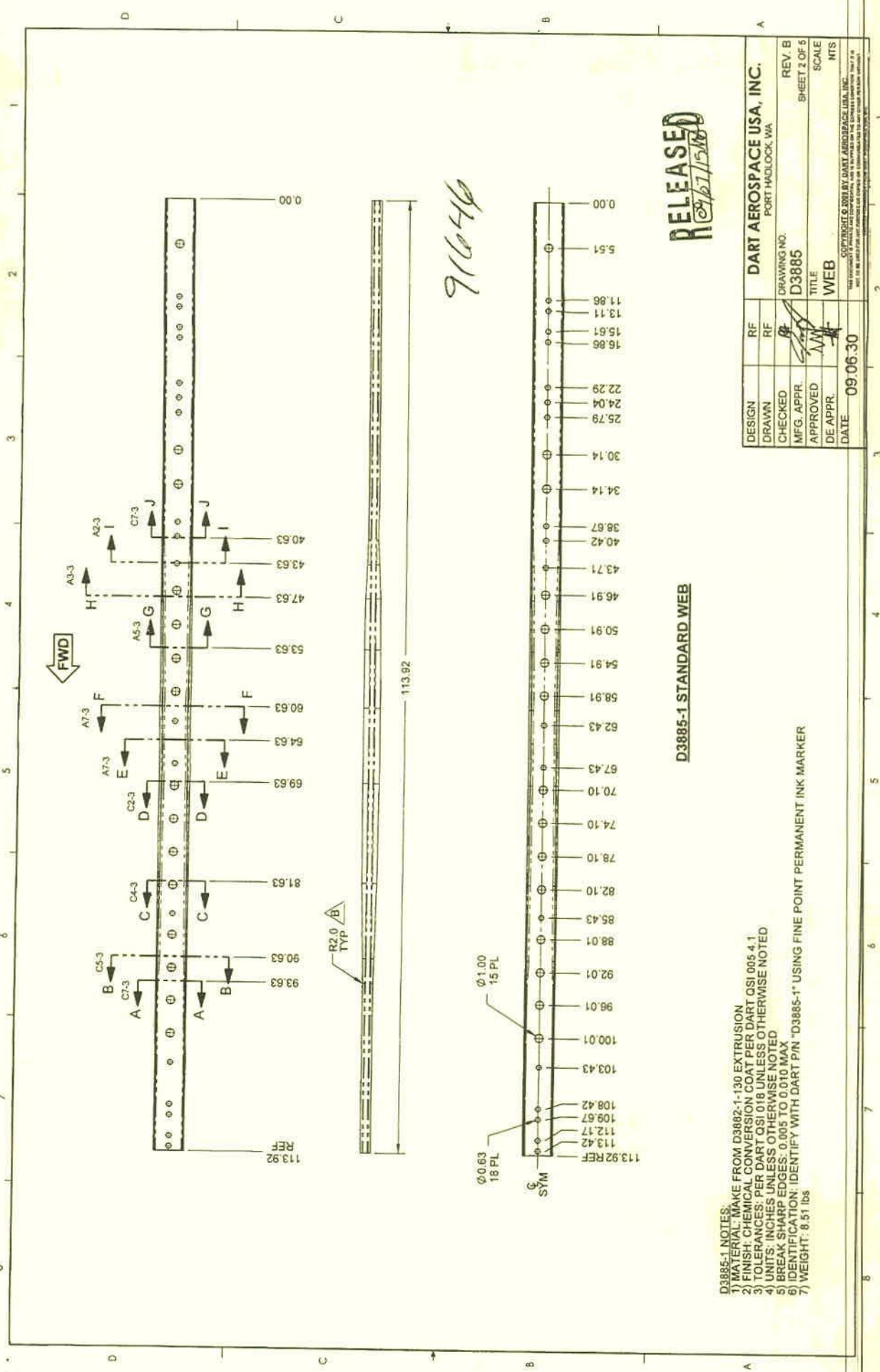
91646
R12-10-18

D3885-1 STANDARD WEB

D3885-3 FLOAT WEB

RELEASED
09/15/18

B	ADD 0.32 (ZN D7-3, D5-3, D7-5, D5-5); ADD 0.24 (ZN B2-3, B3-5). ADD R2.0 TYP (ZN C6-2 & C6-4)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3885	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR		WEB	NTS
DATE	09.06.30	<small>COPYRIGHT © 2006 BY DART AEROSPACE USA, INC.</small> <small>THIS DOCUMENT IS PRELIMINARY AND UNCONTROLLED. IT IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY SUBSTITUTION TO ANY OTHER PERSONAL RECORD.</small> <small>VERIFIED FOR RELEASE FROM DART AEROSPACE USA, INC.</small>	



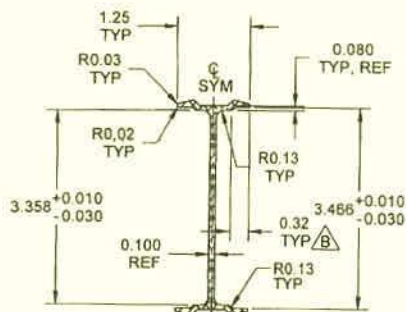
- D3885-1 NOTES:
- 1) MATERIAL: MAKE FROM D3882-1-130 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 016 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK: SQUARE EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3885-1" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 8.51 lbs

RELEASED
R 04/17/5160

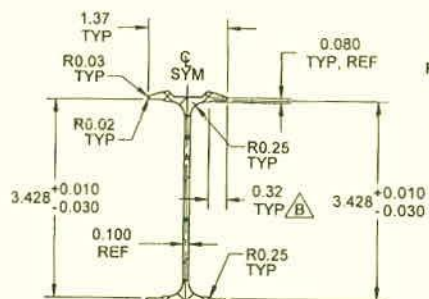
D3885-1 STANDARD WEB

DESIGN	RF	RF	DART AEROSPACE USA, INC.
DRAWN	RF	RF	PORT HADLOCK, VA
CHECKED			DRAWING NO. REV. B
MFG. APPR.			D3885 SHEET 2 OF 5
APPROVED			TITLE WEB SCALE
DE APPR.			NTS
DATE	09.06.30		

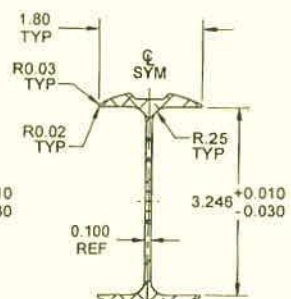
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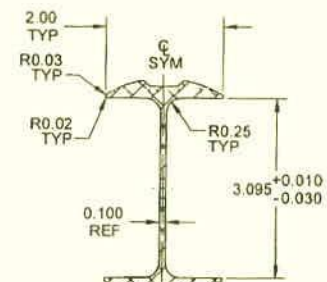
**SECTION A-A
& SECTION J-J**
SCALE 5X
D6-2
D4-2



SECTION B-B
SCALE 5X
D6-2

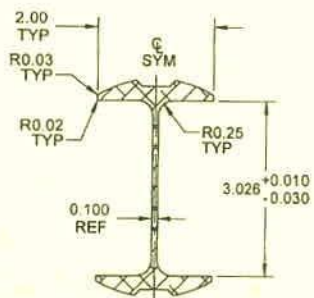


SECTION C-C
SCALE 5X
D6-2

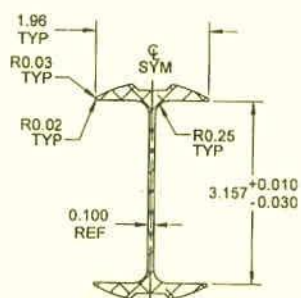


SECTION D-D
SCALE 5X
D5-2

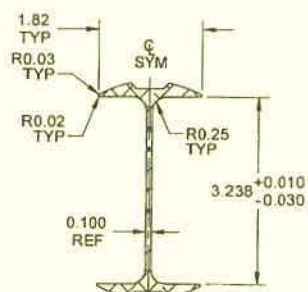
91044



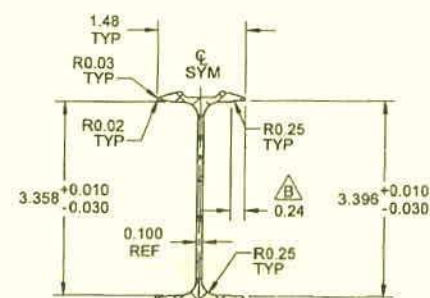
**SECTION E-E
& SECTION F-F**
SCALE 5X
D5-2



SECTION G-G
SCALE 5X
D4-2



SECTION H-H
SCALE 5X
D4-2

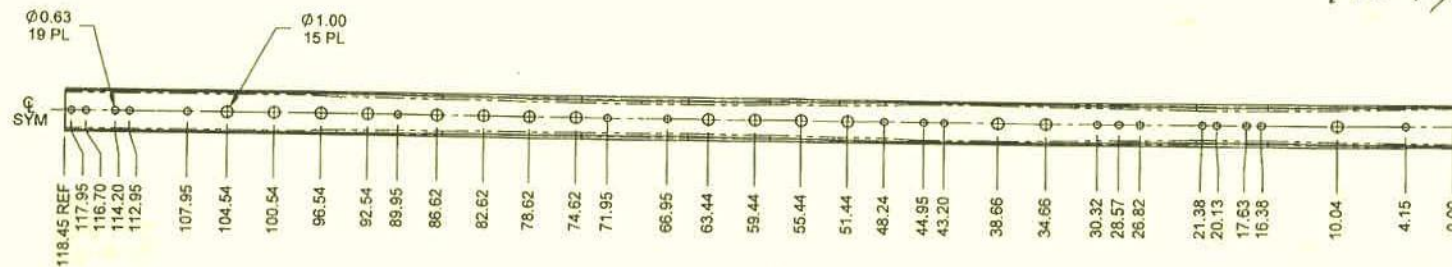
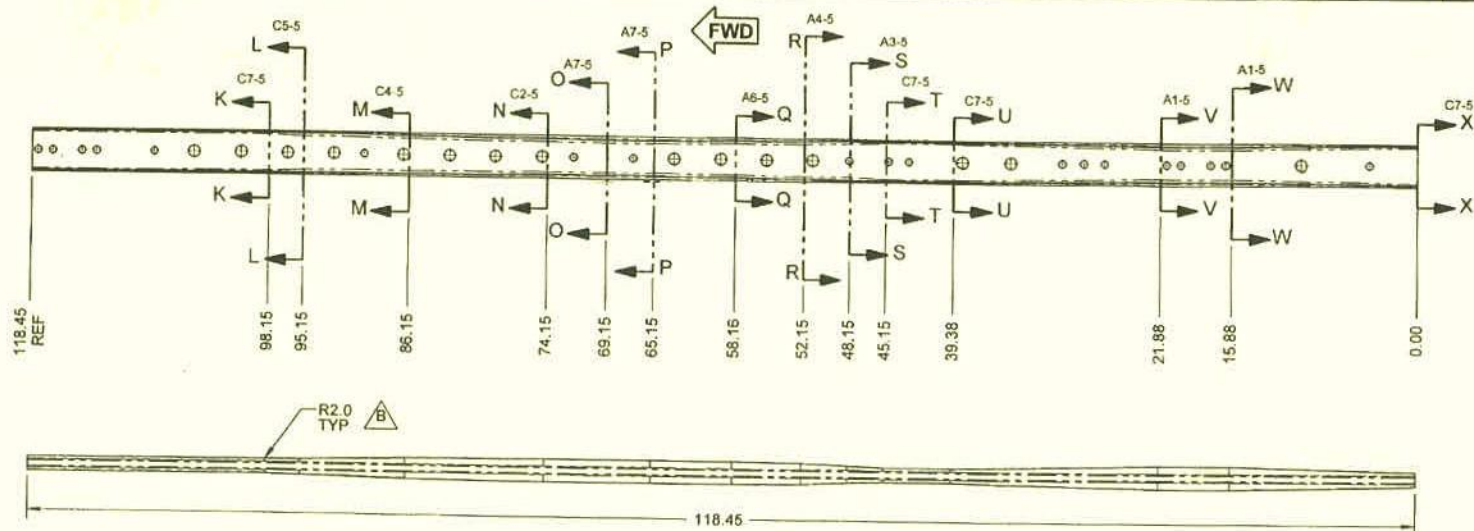


SECTION I-I
SCALE 5X
D4-2

RELEASED
9/17/15

D3885-1 STANDARD WEB SECTION VIEWS

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3885	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEB	NTS
DATE	09.06.30	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC.	



D3885-3 FLOAT WEB

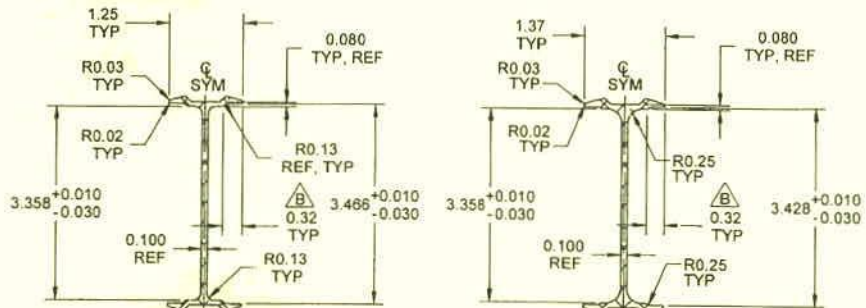
RELEASED
09/07/15/AN

D3885-3 NOTES:

- 1) MATERIAL: MAKE FROM D3882-1-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3885-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 10.14 lbs

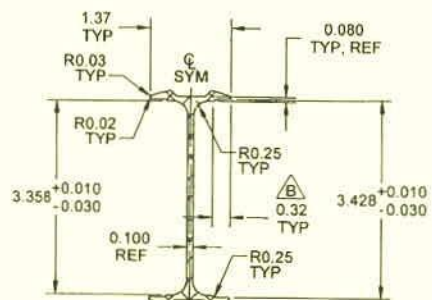
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3885	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEB	NTS
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8 7 6 5 4 3 2 1

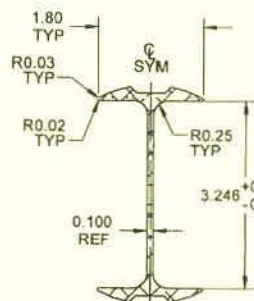


**SECTION K-K
& SECTION T-T
& SECTION U-U
& SECTION X-X**
SCALE 5X

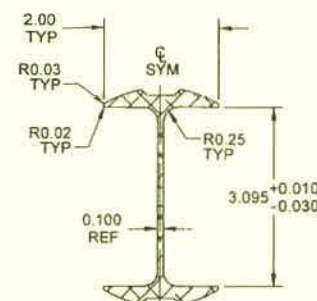
D7-4
D4-4
D3-4
D1-4



SECTION L-L D6-4
SCALE 5X



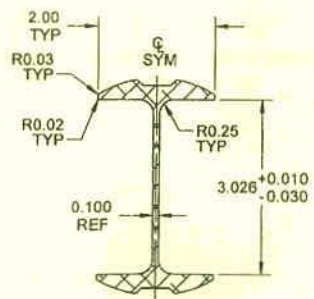
SECTION M-M D6-4
SCALE 5X



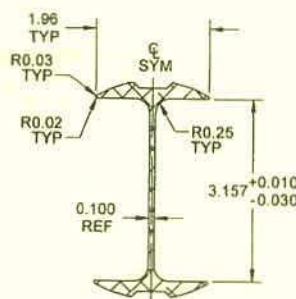
SECTION N-N D5-4
SCALE 5X

91646

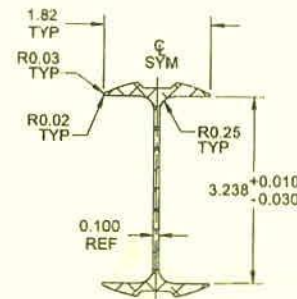
RELEASED
8/17/15



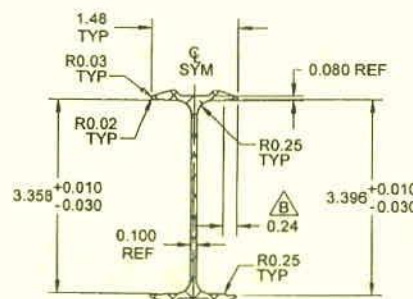
**SECTION O-O
& SECTION P-P** D6-4
SCALE 5X



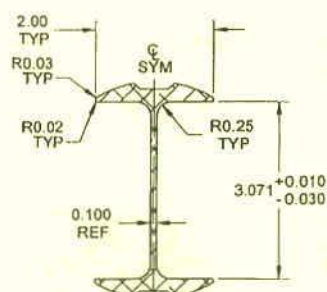
SECTION Q-Q D4-4
SCALE 5X



SECTION R-R D4-4
SCALE 5X



SECTION S-S D4-4
SCALE 5X



**SECTION V-V
& SECTION W-W** D3-4
D2-4
SCALE 5X

D3885-3 FLOAT WEB SECTION VIEWS

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.		D3885	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEB	NTS
DATE	09.06.30	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1



600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3

PHONE: (613) 384-1662


FAX: (613) 384-2997

CERTIFICATE OF COMPLIANCE

CUSTOMER: Dart Aerospace		DATE: Dec. 7, 2012	
		P.O.# PO18242	
		WEJAY JOB# 36044	
I hereby certify that the following material has been inspected/tested and conforms to the requirements and specifications as stated in your contract and as noted below. Any exceptions will be listed as NCR items.			
PART NO.	QTY.	PROCESS (ES)	SPECIFICATION / REV
D3885-1 'standard Web'	6	Machined complete per drawing req'ts.	D3885 / rev. B
Note: 1) Material supplied by Dart Aerospace. 2) 1st Article Inspection report attached.			

Records of Inspection/Test will be retained for 5 years minimum.

Yours truly,


Clifford Smith
Authorized Q.A. Signatory



600 O'CONNOR DRIVE
KINGSTON, ONTARIO
K7P 1N3

INSPECTION / TEST REPORT

JOB No.

36044

PAGE: 1 of 3

CUSTOMER: Dart Aerospace

CUST. P.O.# PO18242

PART No. D3885-1

DESCRIPTION: Standard Web

DWG No. D3885

REV. B

E.C.O.

MATERIAL:

Extrusions supplied by DAS

INSPECTOR

QUANTITY
REC'D:

ACCEPT:

REJECT:

N.C.R.#

DATE:

INSTRUCTIONS, COMMENTS:

ITEM REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
1	Hole, Diameter .63"	18 places	+0.008/-0.001		.629 x 18		
2	Hole, Diameter 1.00"	15 places	+0.010/-0.001		.999 x 15		
3	5.51"		+/- .03		5.511		
4	11.86"		+/- .03		11.859		
5	13.11"		+/- .03		13.111		
6	15.61"		+/- .03		15.612		
7	16.86"		+/- .03		16.861		
8	22.29"		+/- .03		22.292		
9	24.04"		+/- .03		24.042		
10	25.79"		+/- .03		25.792		
11	30.14"		+/- .03		30.140		
12	34.14"		+/- .03		34.14		
13	38.67"		+/- .03		38.668		
14	40.42"		+/- .03		40.420		
15	43.71"		+/- .03		43.71		
16	46.91"		+/- .03		46.910		
17	50.91"		+/- .03		50.910		
18	54.91"		+/- .03		54.910		
19	58.91"		+/- .03		58.910		
20	62.43"		+/- .03		62.430		
21	67.43"		+/- .03		67.430		
22	70.10"		+/- .03		70.100		
23	74.10"		+/- .03		74.100		
24	78.10"		+/- .03		78.100		
25	82.10"		+/- .03		82.100		
26	85.43"		+/- .03		85.430		
27	88.01"		+/- .03		88.010		
28	92.01"		+/- .03		92.010		
29	96.01"		+/- .03		96.010		
30	100.01"		+/- .03		100.010		
31	103.43"		+/- .03		103.430		
32	108.42"		+/- .03		108.420		
33	109.67"		+/- .03		109.670		
34	112.17"		+/- .03		112.170		
35	113.42"		+/- .03		113.420		
36	113.92" REF				113.925		



600 O'CONNOR DRIVE
KINGSTON, ONTARIO
K7P 1N3

INSPECTION / TEST REPORT

JOB No.

36044

PAGE: 2 of

3

CUSTOMER: Dart Aerospace

CUST. P.O.# PO18242

PART No. D3885-1

DESCRIPTION: Standard Web

DWG No. D3885

REV. B

E.C.O.

MATERIAL:

Extrusions supplied by DAS

INSPECTOR:

QUANTITY
REC'D:

ACCEPT:

REJECT:

N.C.R.#

DATE:

INSTRUCTIONS, COMMENTS:

ITEM REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
37	1.25" TYP	Section A-A,J-J@93.63",40.63"	$\pm .03$		1.263		
38	R.03" TYP				✓		
39	R.02" TYP				✓		
40	3.358"		$+0.010/-0.030$		3.344/3.342		
41	R.13" TYP				✓		
42	.32" TYP				.320		
43	3.466"		$+0.010/-0.030$		3.438		
44	R.13" TYP				✓		
45	.080 TYP,REF				✓		
46	1.37" TYP	Section B-B@90.63"	$\pm .03$		1.379		
47	R.03" TYP				✓		
48	R.02" TYP				✓		
49	3.428"	2 places	$+0.010/-0.030$		3.399,2		
50	R.25" TYP				✓		
51	.32" TYP				.320		
52	R.25" TYP				✓		
53	.080" TYP,REF				✓		
54	1.80" TYP	Section C-C@81.63"	$\pm .03$		1.797		
55	R.03" TYP				✓		
56	R.02" TYP				✓		
57	3.246"		$+0.010/-0.030$		3.233		
58	R.25" TYP				✓		
59	2.00" TYP	Section D-D@69.63"	$\pm .03$		1.996		
60	R.03" TYP				✓		
61	R.02" TYP				✓		
62	3.095"		$+0.010/-0.030$		3.082		
63	R.25" TYP				✓		
64	2.00" TYP	Section E-E,F-F@64.63",60.63"	$\pm .03$		1.996		
65	R.03" TYP				✓		
66	R.02" TYP				✓		
67	3.026"		$+0.010/-0.030$		3.005/3.207		
68	R.25" TYP				✓		
69	1.96"	Section G-G@53.63"	$\pm .03$		1.996		
70	R.03" TYP				✓		
71	R.02" TYP				✓		
72	3.157		$+0.010/-0.030$		3.140		



600 O'CONNOR DRIVE
KINGSTON, ONTARIO
K7P 1N3

INSPECTION / TEST REPORT

JOB No. 36044

PAGE: 3 of 3

CUSTOMER: Dart Aerospace

CUST. P.O.# PO18242

PART No. D3885-1

DESCRIPTION: Standard Web

DWG No. D3885

REV. B

E.C.O.

MATERIAL:

Extrusions supplied by DAS

INSPECTOR:

QUANTITY
REC'D:

ACCEPT:

REJECT:

N.C.R.#

DATE:

INSTRUCTIONS, COMMENTS:

ITEM REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
73	R.25" TYP	Section G-G Cont'd			✓		
74	1.82"	Section H-H@47.63"	$\pm .03$		1.810		
75	R.03" TYP				✓		
76	R.02" TYP				✓		
77	3.238"		$+.010/-0.030$		3.222		
78	R.25" TYP				✓		
79	1.48"	Section I-I@43.63"	$\pm .03$		1.476		
80	R.03" TYP				✓		
81	R.02" TYP				✓		
82	3.358		$+.010/-0.030$		3.350		
83	R.25" TYP				✓		
84	3.396"		$+.010/-0.030$		3.374		
85	R.25" TYP				✓		
86							
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